C

October 5, 2009 8:06:59 AM

Item ID:

Reference:

Sequence ID/

Draw Nbr

D3144

100

Work Center ID

D3144-107

Revision ID:

Doubler Item Name:

Start Date:

Required Date: 10/06/09

10/05/09

Start Qty: 10.00

Operation

Revision Nbr

Rev C

Description

PURCHASING

Req'd Qty: 10.00

Approvals:

QC:

Process Plan:

Date:

Date:

Tooling:

SPC (Y/N):

0.00

0.00

Accept

Set Up/

Run Hours

Number

Draw

Date:

Date:

Cust Item ID:

Customer:

Draw Rev.

Plan Code

Accept Qty

Reject Qty

Number Stamp



Waterjet FLOW CNC Waterjet

Memo

1-Cut as per Dwg D3144

Dwg Rev: Prog Rev:

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

Quality Control

Memo

0.00

B910-5

Run

Setup Start

Stop

Stop

Start

Reject

Insp.

C

October 5, 2009 8:06:59 AM

Item ID:

D3144-107

Revision ID:

Item Name:

Start Date:

10/05/09

Doubler

Required Date: 10/06/09

Req'd Qty: 10.00

Start Qty: 10.00



Accept



Setup Start



Stop



Cust Item ID:

Customer:

Reference:

Approvals: **Process Plan:**

QC:

Date: Date: **Tooling:**

SPC (Y/N):

Date:

Date:

Start Run

Stop



Sequence ID/ Work Center ID

120

Quality Control

Operation Description

QC8- Inspect parts - second check

Set Up/ Run Hours Draw Number Draw Rev.

Plan Code

Accept Qty

Reject Qty

Reject Number Stamp

Insp.

Memo

0.00

2) Sor/10/05 0.00

130

Small Fab

Small Fab

Small Fab

Deburr if necessary

0.00

0.00

140

HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.00

09/10/05

 \mathbf{C}

October 5, 2009 8:07:00 AM

Item ID:

D3144-107

Revision ID:

Doubler Item Name:

Start Date:

10/05/09

Required Date: 10/06/09

OC:

Start Qty: 10.00 Req'd Qty: 10.00



Accept



Setup Start



Stop

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: Date: Tooling:

SPC (Y/N):

Date:

Date:

Run Start

Stop

Sequence ID/

Work Center ID

Powder Coating

Operation Description

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

M/09A1

Memo

Set Up/ **Run Hours**

0.00

Draw Number Draw Rev.

Plan Code

Accept Qty

Reject Qty

Reject Number

Insp. Stamp

Powdercoat

Memo

FINISH TIME:

BL 09-10-5

160

150

Quality Control

QC3- Inspect Part Finish

170

Packaging Packaging

Identify as per dwg & Stock Location: ___C ?

0.00

Memo

0.00

Pegh-1-18)

October 5, 2009 8:07:00 AM

Item ID:

D3144-107

C **Revision ID:**

Doubler Item Name:

Start Date:

10/05/09

Start Qty: 10.00 Required Date: 10/06/09

Req'd Qty: 10.00

Operation

Reference:

Approvals: Process Plan:

QC:

Date: Date:

SPC (Y/N):

0.00

0.00

Set Up/

Run Hours

Tooling:

Description QC21- Final Inspection - Work Order Release

Sequence ID/

Work Center ID

Quality Control

180

Memo

Accept

Setup Start



Stop

Start

Cust Item ID: **Customer:**

Date:

Date:

Run

Stop

Draw Number

Draw Rev.

Plan Qty Code

Accept Qty

Reject Reject

Insp. Number Stamp

09/10/05

Picklist Print

October 5, 2009 8:06:58 AM

Work Order ID: 52616

Parent Item:

D3144-107RevC

Parent Item Name:

Doubler

Comments:

Component	Item	ID/
Item Name		

Replacement Mfg/ Item ID Purch

M2024T3S.032

Purchased



2024-T3 .032 sheet



Last

Location

Route

Seq ID

100

Primary

Item Location

No

Start Date: 10/05/09

Start Qty: 10.00

Remaining

Required Date: 10/06/09

Required Qty: 10.00

Date Issued

Status

2:00 80.4179 3.0737

Qty To Pick Issued

Qty

IB 9-10-5

Warehouse	Loc Oty	Loc Code	
Location			
Main Warehouse			
MAT	80.41793158		
102942	1.5		
105555	4.0684		
106272	5.3		
108595	1.2		
109240	7.02		
110778	23.9106316		110778)
111699	34.4189		
18147	3		

Unit of

sf

Measure Hand

Qty on

DART AEROSPACE LTD	Work Order: 57616	
Description: Double 2	Part Number: D3144-1	তা
Inspection Dwg: 72144-67Rev:	Page 1	of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

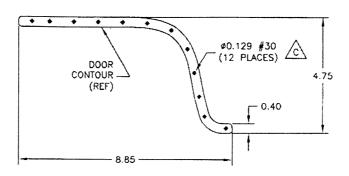
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
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Measured by:	B	Audited by:	2,	Prototype Approval:	N/A
Date:	9-10-6	Date:	09/10/65	Date:	N/A

Rev	Date	Change	Revised by	Approved
1.0.	+	New Issue	KJ/JLM	

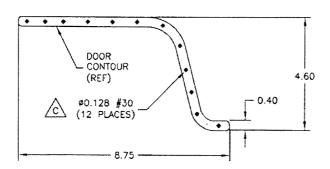


DESIGN RF	DRAWN BY RF		ROSPACE LTD
CHECKED ,/	APPROVED //	DRAWING NO.	REV. C
#	#	D3144	SHEET 7 OF 9
DATE		TITLE	SCALE
05.10.19		DOUBLER	NTS





D3144-107 DOUBLER (FOR D412-694-03)



D3144-121 DOUBLER (FOR D412-694-04)



D3144-107/-121 NOTES:

- 1) MATERIAL: 2024-T3 SHEET (QQ-A-250/4) 0.032 THICK (REF DART SPEC M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3

- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MACHINE PER DRAWING FILE "D3144-C7.DWG"

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